Work Order ID 73960

Tuesday, September 20, 2011 10:18:28 AM

Item ID: D2746
Revision ID:
Item Name: Wearshoe
Start Date: 9/20/2011 **Start Qty:** 6.00
Required Date: 10/4/2011 **Req'd Qty:** 6.00
Reference:

Accept

Setup **Start**
Stop

Cust Item ID:
Customer:

Approvals: **Process Plan:** MF **Date:** 11-09-20 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run **Start**
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2746	Rev C								
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet 1010 .040	1-Cut as per Dwg D2746 ☐Dwg Rev: C ☐Prog Rev: C ☐2- Deburr if necessary					B11-9-20			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				B11-9-20			
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

6

S 11/09/21

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run **Start**
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab Small Fab	Small Fab	0.00							
	Memo Deburr if necessary.	0.00							
140 Brake NC Brake NC	NC BRAKE	0.00				6			
	Memo 1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261and DT8326□2-Form joggle on Punch as per Dwg D2746 using Jig DT8158Identify as D2746	0.00							
150 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				6			
	Memo	0.00							

N/A

Sb 11/09/22

Sb 11/09/22

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat									
	Memo	0.00							
Powder Coating	START TIME: 1:15	OVEN TEMPERATURE: 320 °F							
M117338	FINISH TIME: 1:45								
170	QC3- Inspect Part Finish	0.00							
QC									
	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: 4A	0.00							
Packaging									
	Memo	0.00							
Packaging									

6x Ø m-f 11/04/22

6 BK 11-9-22

11/9/23 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Work Order ID 73960

Tuesday, September 20, 2011 10:18:28 AM

Item ID: D2746
Revision ID:
Item Name: Wearshoe

Accept

Setup Start
Stop

Start Date: 9/20/2011 **Start Qty:** 6.00
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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							11/9/2023
QC Quality Control	**Memo**	0.00							MF 11-09-23

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:18:25 AM

Work Order ID: 73960

Parent Item: D2746

Parent Item Name: Wearshoe

Start Date: 9/20/2011 **Required Date:** 10/4/2011

Start Qty: 6.00 **Required Qty:** 6.00

Comments:
IPP Rev: D□02.10.24□Re-format□KJ
IPP Rev: E 06-03-21 as Per Rev C JLM
IPP Rev: F 06-06-12 Now On Waterjet JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA 1010/1025 SHEET		Purchased	No			110	sf	139.7000	0.406	2.564211 HB 11-9-20			

Location	Loc Qty	Loc Code
MAT019	139.7	
111410	53.2	
116791	86.5	

116791

6

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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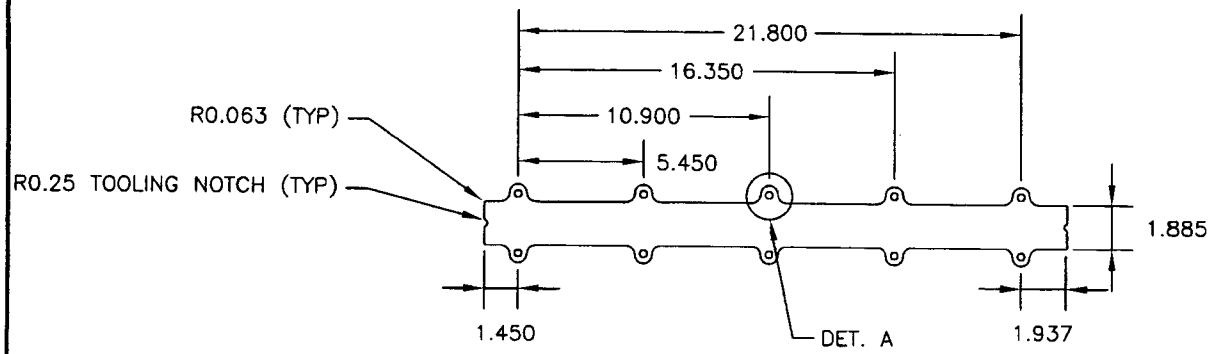
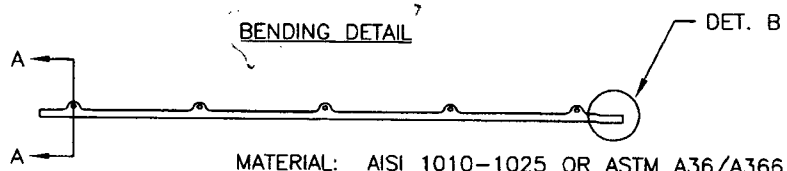
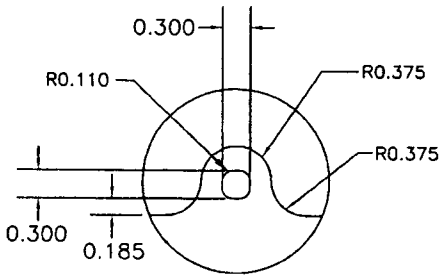
FLAT PATTERN



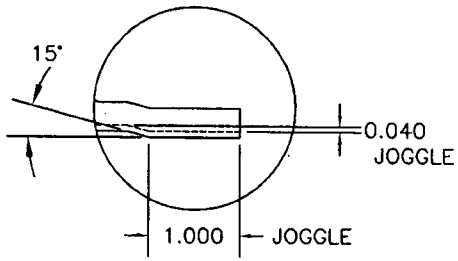
BENDING DETAIL



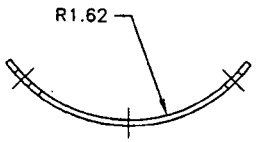
MATERIAL: AISI 1010–1025 OR ASTM A36/A366/A1008 OR CSA G40–21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)



DETAIL A



DETAIL B



SECTION A–A

#73960

NOTES

1) MATERIAL: AISI 1010–1025 OR ASTM A36/A366/A1008 OR CSA G40–21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)
2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) THIS PART CAN BE MADE BY MODIFYING D2656–21

RELEASED

A	98.04.16	NEW ISSUE
B	98.08.18	RE–DESIGN
C	06.01.12	ENLARGE HOLES TO IMPROVE FIT

DART

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DESIGN	DRAWN BY	DRAWING NO.	REV. C
CHECKED	APPROVED	D2746	SHEET 1 OF 1
DATE 06.01.12		TITLE WEARSHOE	SCALE 1:8

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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD	Work Order:	73960
Description: Wearshoe	Part Number:	D2746
Inspection Dwg: D2746 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300	+/-0.010	.301	✓		V HBOZ	
1.885	+/-0.010	1.888	✓		V	
5.450	+/-0.010	5.448	✓		V	
10.900	+/-0.010	10.899	✓		PROWIZ	

Measured by:	[illegible]	Audited by:	[illegible]	Prototype Approval:	N/A
Date:	11-9-20	Date:	11/02/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue	KJ/JLM [illegible]	[illegible]

Dart Aerospace Ltd

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